

Work Order ID 149073

Tuesday, July 19, 2016 2:43:17 PM

149073

Page 1

Item ID: D5032-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 7/14/2016 Start Qty: 64.00 ***64*** Cust Item ID:
 Required Date: 7/19/2016 Req'd Qty: 64.00 ***64*** Customer:

Reference: **DAS**
21
 Approvals: Process Plan: **9-89** Date: **JUL 20 2016** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5032	A								PR 2016/07/24
110		0.01							
110						72		DAS 20 9-89	16-07-25
Waterjet	Memo	0.11							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120						72			PR 2016/07/24
QC	Memo	0.11							
Quality Control								DAS 20 9-89	16-07-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 149073

Tuesday, July 19, 2016 2:43:17 PM

149073

Page 3

Item ID: D5032-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 7/14/2016 Start Qty: 64.00 ***64*** Cust Item ID:
Required Date: 7/19/2016 Req'd Qty: 64.00 ***64*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location ST143	0.00				72	DE		JUL 26 2016
160									
Packaging	Memo	0.11							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	1.07							
Quality Control									

DAS
21
9-89

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : _____																									

Picklist Print

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Page 1

Work Order ID: 149073

149073

Parent Item: D5032-3

D5032-3

Parent Item Name: Doubler

Start Date: 7/14/2016

Required Date: 7/19/2016

Start Qty: 64.00

Required Qty: 64.00

Comments: IPP REV:A NEW ISSUE 13.12.20 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

sf

199.9000

1.010526

M6061T6S 040

R206/07/24

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

199.9

m132037

2

m133548

49.4

m134774

75.8

m135147

72.7

1.6

DQA: _____ Date: _____

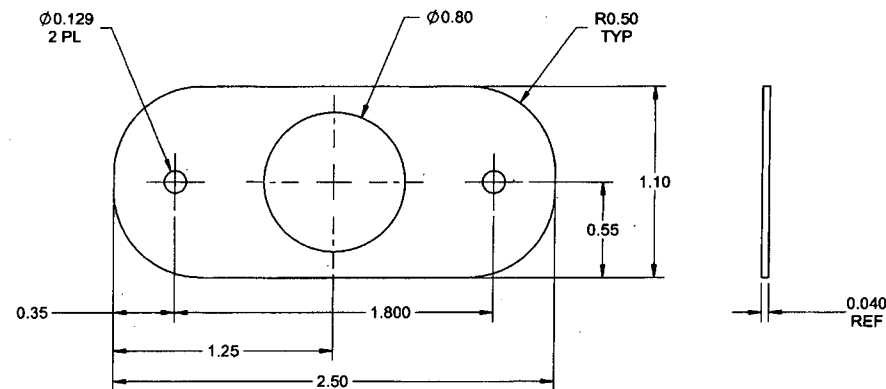


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		OTHER :							



D5032-1 DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 149073 MJS
16-07-80

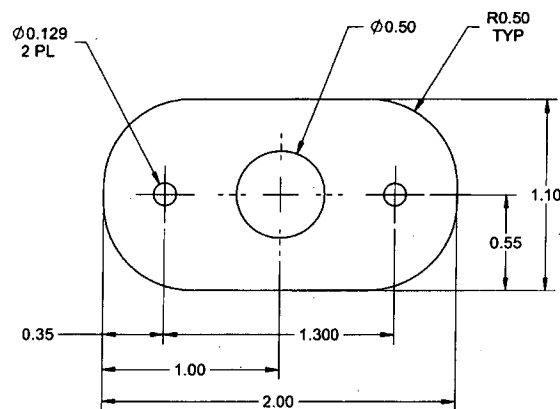
RELEASED
2013-12-23
135 ECN 13-705

A NEW ISSUE		RF	13.12.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>DC</i>		
MFG. APPR.	<i>DS</i>		
APPROVED	<i>SH</i>		
DE APPR.			
DATE	13.12.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5032** REV. A
SHEET 1 OF 2
TITLE **DOUBLER** SCALE NTS

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.



D5032-3 DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
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- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
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